

Date: Friday, 09/11/2007 1:48:34 PM  
User: Linda Lacelle

## Process Sheet

**Customer** : CU-DAR001 Dart Helicopters Services  
**Job Number** : 35609  
**Estimate Number** : 12473  
**P.O. Number** : N/A  
**This Issue** : 09/11/2007 **S.O. No.** : N/A  
**Prsht Rev.** : NC  
**First Issue** : M/A **Type** : SMALL / MED FAB  
**Previous Run** : 30748  
**Written By** :  
**Checked & Approved By** :  
**Comment** : Est Rev:A New Issue 06-06-22 JLM

**Drawing Name** : MOUNTING BRACKET  
**Part Number** : D3246041  
**Drawing Number** : D3246 REV A1  
**Project Number** : N/A  
**Drawing Revision** : A1  
**Material** : N/A  
**Due Date** : 14/11/2007 **Qty:** 4 **Um:** Each

### Additional Product

Job Number:



**Seq. #:** **Machine Or Operation:** **Description :**

1.0 M2024T3S050 2024-T3 .050 sheet



**Comment:** Qty.: 0.3252 sf(s)/Unit Total : 1.3007 sf(s)

2024-T3 .050 sheet

Material: 2024-T3 (QQ-A-250/4) 0.050" thick

(M2024T3S.050)

Identify for D3246-1 Batch: 103321 HB 07-11-12

2.0 WATER JET FLOW WATER JET



**Comment:** FLOW WATER JET

1-Cut as per Dwg Dsi9279

Dwg Rev: A1

Prog Rev: A1

2-Deburr if necessary

HB



3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



**Comment:** SECOND CHECK

5.0 BRAKE NC NC BRAKE



**Comment:** NC BRAKE

Deburr

Form as per Dwg D3246

C'sink as per Dwg D3246

S/S 07/11/12  
mf 07-11-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3246041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



07-11-12 (7)



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



MS



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-11-12

(X7)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07/11/12

9.0

MS20426AD33

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Rivet

Pick:

Qty Part Number Description Batch

8 MS20426AD3-3 Rivet

m1563

MF

10.0

MS21059L3

Nut Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut Plate

Pick:

Qty Part Number Description Batch

4 MS21059L3 Nut Plate m101588

07-11-12

X

Identify as D3246-041

MF

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates as per Dwg D3246

MF 07-11-12 (7)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 07/11/12 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/11/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: C-7/11/12 (7)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(7)

Comment: FINAL INSPECTION/W/O RELEASE

207/11/13

Job Completion

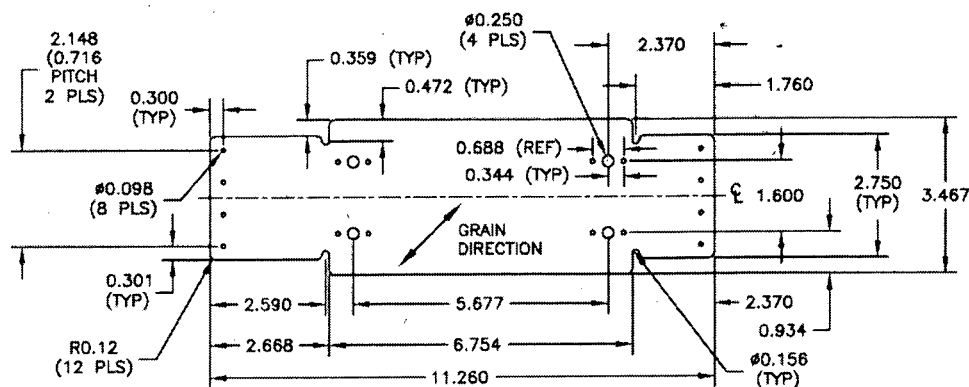


U 07-11-13

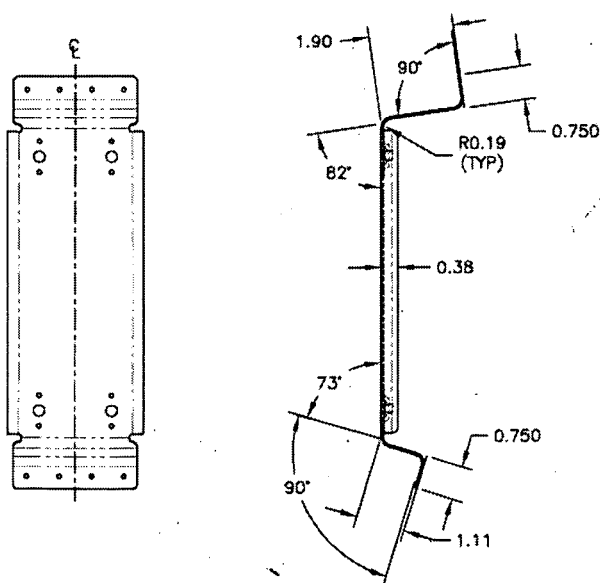


DESIGN JH	DRAWN BY JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3246	REV. A SHEET 1 OF 1
DATE 04.04.21		TITLE MOUNTING BRACKET	SCALE 1:4
A	04.04.21	NEW ISSUE	
AI	04.06.16	CHANGE RIVET; ADDED C-SINK	

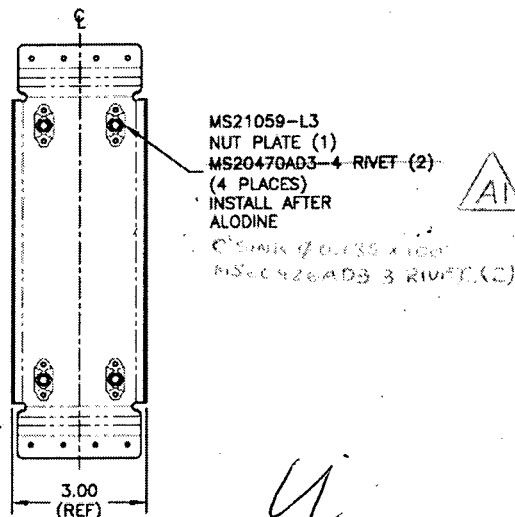
RELEASED  
04.05.07



D3246-1 FLAT PATTERN



D3246-1 BEND DETAIL



D3246-041 ASSEMBLY

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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